Work Order ID 62199

Wednesday, September 22, 2010 10:22:53 A

Item ID: D4154-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Plate

Start Date: 9/22/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 9/29/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-9-22 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4154 / Revision Nbr: A									
100		0.00							
Waterjet	**Memo**	0.00				IB 10-9-22			
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary					(4)			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				IB 10-9-22			
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62199

Wednesday, September 22, 2010 10:22:53 A

Item ID: D4154-1 **Accept** **Setup Start**

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Item Name: Plate

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				(+4)			
130 Brake NC Brake NC	Form as per dwg **Memo**	0.00 0.00				(4)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				(+4)			

10/04/23

SB 10/09/23

10/04/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62199

Wednesday, September 22, 2010 10:22:53 A

Item ID: D4154-1
Revision ID:
Item Name: Plate
Start Date: 9/22/2010 **Start Qty:** 4.00
Required Date: 9/29/2010 **Req'd Qty:** 4.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging	Identify as per dwg & Stock Location: ERIC L	0.00					4.0		10/9/27
	Memo	0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							10/09/27 MF 10-9-27
	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, September 22, 2010 10:22:57 AM

Work Order ID: 62199

Parent Item: D4154-1

Parent Item Name: Plate

Start Date: 9/22/2010 **Required Date:** 9/29/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	127.9479	4.2697	17.97768			
304/316 .050 Sheet													

Location	Loc Qty	Loc Code
MAT20	127.9479	
111743	7.36	
112885	10.4179	
113062	58.17	
115389	52	

BB 10-9-23

(4)

113062

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62199
Description: PLATE	Part Number:	D4154-1
Inspection Dwg: D4154-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+.005 -.001	.191	X		V 1B02	
Ø .516	+.008 -.001	.516	X		V	
.88	+/- .030	.88	X		V	
.175	+/- .010	.175	X		V	
.25	+/- .030	.253	X		V	
.400	+/- .010	.403	X		V	
.050	+/- .010	.050	X		V	
.55	+/- .030	.550	X		V	
4.75	+/- .030	4.751	X		V	
4.00	+/- .030	4.003	X		V	
14.00	+/- .030	14.00	X		T 1B01	
61.00	+/- .030	61.000	X		T	
91.50	+/- .030	91.50	X		T	
1.20	+/- .030	1.204	X		V	
1.80	+/- .030	1.808	X		V	
2.75	+/- .030	2.75	X		V	
6.42	+/- .030	6.422	X		V	
15.45	+/- .030	15.45	X		T	
40.70	+/- .030	40.70	X		T	
66.45	+/- .030	66.45	X		T	
90.35	+/- .030	90.35	X		T	
6.72	+/- .030	6.715	X		V	
.050	+/- .010	.052	X		V	

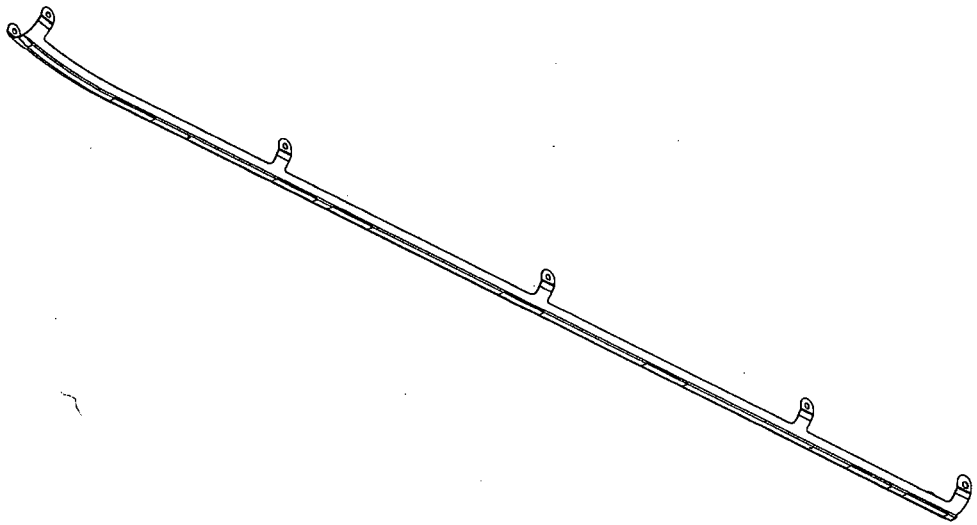
Measured by:	IB
Date:	10-9-23

Audited by:	S
Date:	10/09/23

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62109
DS 10-9-22

D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010 -09- 15

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	SC	10.07.22

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	SC	
CHECKED		DRAWING NO. D4154 REV. A
MFG. APPR.		SHEET 1 OF 3
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	10.07.22	

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Dart Aerospace Ltd

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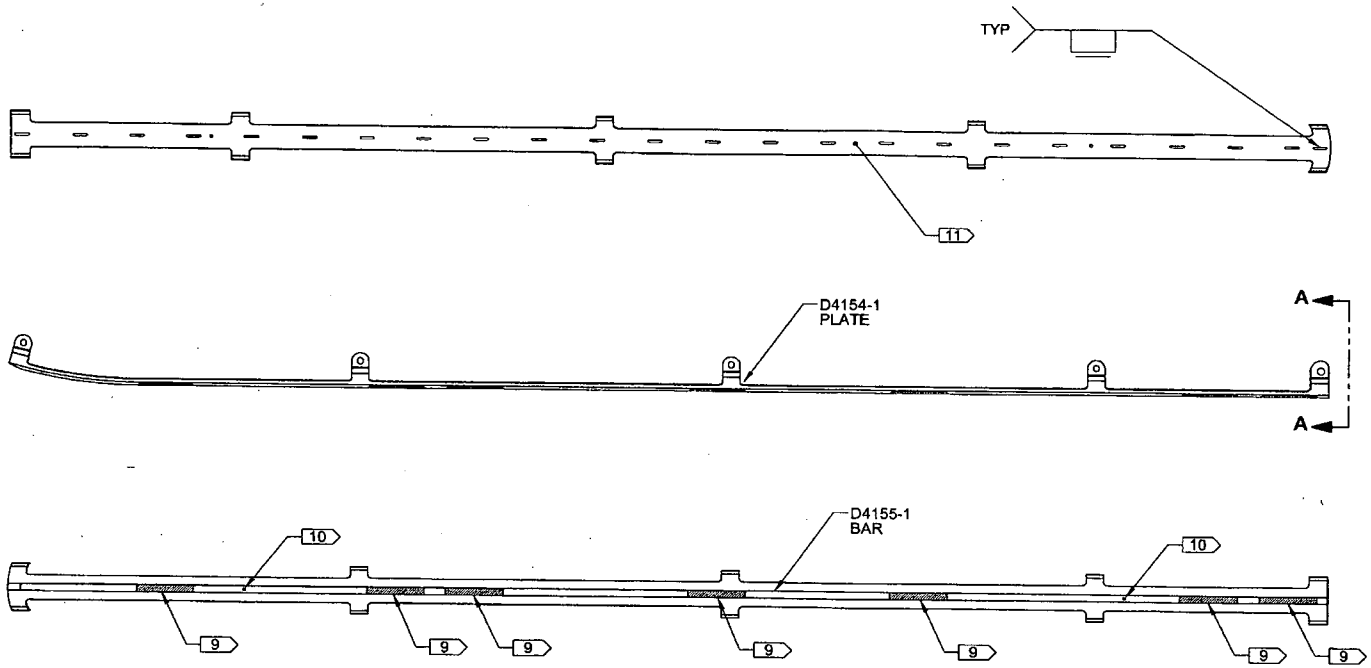
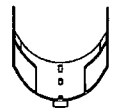
NOTE: Date & initial all entries



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010 -09- 15



SECTION A-A

w/o 62199

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
7) WEIGHT: 5.99 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
10) TRANSFER DRILL ϕ0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	SC	
CHECKED		DRAWING NO. D4154 REV. A
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE	10.07.22	

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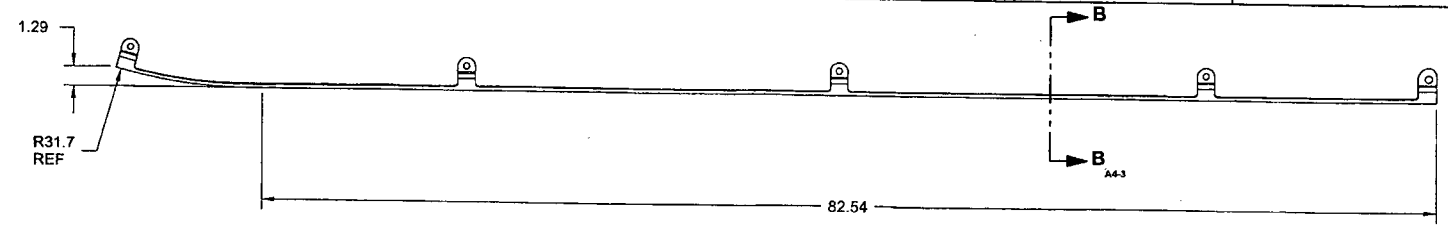
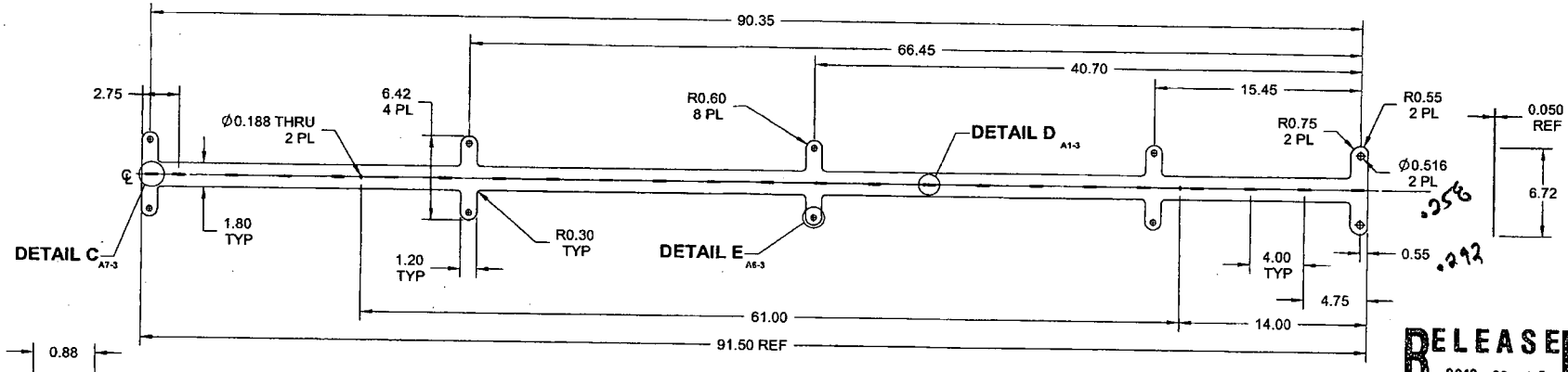
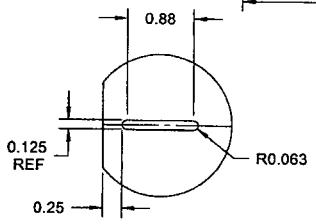


D4154-1 PLATE
(MAKE FROM D4154-1F)

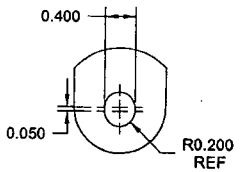


D4154-1F FLAT PATTEN

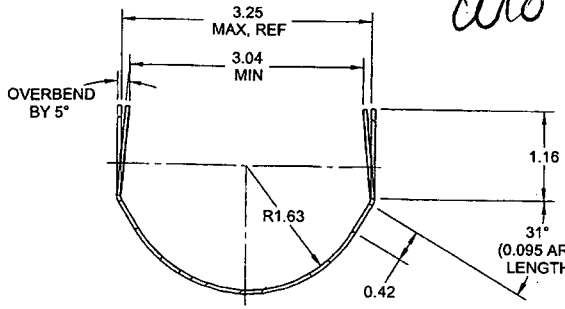
RELEASED
2010 -09- 15



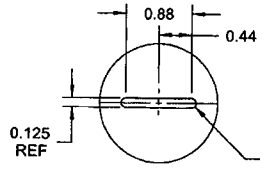
DETAIL C C7-3
SLOT DETAIL TYP



DETAIL E C4-3
SLOT DETAIL TYP



SECTION B-B D3-3



DETAIL D C4-3
SLOT DETAIL TYP

NOTES:
1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
2) FINISH : NONE
3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS : INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
6) IDENTIFICATION : NONE
7) WEIGHT : 2.71 lbs

DESIGN	SC	DART AEROSPACE USA, INC.
DRAWN	SC	PORT HADLOCK, WA
CHECKED		DRAWING NO. D4154 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE WEARPLATE ASSEMBLY SCALE NTS
DE APPR.		
DATE 10.07.22		

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